Quality Control

<b>Work Order</b> September-27-13				*107	7654*						Page 1
Item ID: D Revision ID:	02204-9			Accept	*N900	040	100	)* s	Setup Star	I VI	S1*
Item Name: R	Rubber Latches	s							Stop	' *N	S2*
Start Date: 9	/27/13	Start Qty: 10.00	*10*		Cust Item I	D:					
Required Date: 9	/27/13	Req'd Qty: 10.00	*10*		Customer:						
Reference:			D + 10 00 2 m					F	Run Star	<sup>t</sup> *NI	R1*
		n: _MC3	Date: 13-09-30			ate:			Stop		
•	QC:		Date:	SPC (Y/N):	Da	ate:			_	*N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr				· · · · · · · · · · · · · · · · · · ·					
D2204	Rev	B							•		
100				0.00					· .		
*100*		PURCHASING							1_13/1	0/01	(D)
Purchasing		Memo	115-9	0.00					-		
Purchasing		Issue P/O 🖄 RubberP/N:	Make per Dwg D 286750017Material release		Accurate						
110		Receive & Inspect for Da	amage & Mat'l Certs	0.00						(la	
*110*				0.00				///	3/1/	$-(\alpha)$	<i>y</i>
Packaging Packaging		Memo Ensure Mate	erial Release Note is attache				(	/			
			·	DA	s						
120		QC6- Inspect dimensions	s to drawing	0.00 27				١٥		,	
*120*				0.00 13 16	9 '\						
UC		Memo		0.00	1 -1						

											DQA:	Date:	-
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· · · <u> </u>						_					QA Closed:	Date:	
Nork Orde	er:						DISPOSITION			AGAINST D	EPARTMENT	/PROCESS	
Part I		-					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
											_ 		
Root Cause		Date	Step	Qty	Des		otion of work order update or Non-conformance	1	nitial lief Eng	Action Description	Sign & Date	Verification	QC Inspector
oc/Data		Jule	Gtep	٠,٠,٠			Trott comormance	-	iler Elig	Description	Dute	Vermedicit	Qe mspector
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		Centre No	t Concer	ntric to (	o/s		BOM/Route		Hardwa	ire -	Over/Under	tolerance	Temperature/Cure
		Cracks					Broken/Damaged		Inspecti	ion Incomplete	Part Incorred	<b>⊢</b>	Weld
		Crushed/C	Crimped.				Burrs		4	tions Incomplete/Unclear	Part Lost/Mi	<b> </b>	Wrong Stock Pulled
		Cuffs					Contamination		Mainte	F	Part Moved		_ ~
		Heat Treat	t				Countersink		Mislabe	eled	Positioned V	Vrong	
		Inspection	Strip in	Tube		-	Cut Too Short		Misread	, – –	Power Loss/		Other
	_	Ripples in					Drill Holes	1	Offset	<b>L</b>	_ ′		
		Torque W	aves in E	xtrusio	1		Drawing		Out of (	Calibration			
		Turning Se					Finish		Out of S	Sequence	<del> </del>		

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Quality Control

Work Ord September-27-1				*107	654*							Page 2
Item ID: Revision ID:	D2204-9			Accept	*N900	<b>040</b>	100	)*	Setup	Start	*N:	S1*
Item Name:	Rubber Late	hes								Stop	*N:	S2*
Start Date:	9/27/13	Start Qty: 10.00	*10*		Cust Item	ID:						
Required Date: Reference:	9/27/13	Req'd Qty: 10.00	*10*		Customer:					<b>C</b> 4 4		
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:	<del></del>			Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
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Small Fab		Memo		0.00	DAS		ľ				<u></u>	11010
Small Fab		Deburr shar	p edges of steel brackets	~	27 9 <sub>1</sub> 89						,	
ک کن	~				ह्या विश्व			10				
140		White Gloss(Ref:4.3.5.2		0.00	· ·			4.3	/	1 1	<i>,</i> ,	DAS
*140* Powdercoat		Memo	٠,	0.00				10	_ \&	15	D-6.	DAS 34 9-89
Powder Coating		FART TIM	IE: <u>9:30</u> _FINISH TIME:	OVEN TEMPERATURE	:							9-89
150		QC3- Inspect Part Finish	1	0.00 SY	P			<b>1</b>				
*150*				0.00	1/2			<u>N</u>				- <del></del>
QC		Memo		0.00	* ' Y							

MCD.	Voc	1	NI.
NCR:	Yes	/	No

											DQA:	Date	*
NCR: Y	es	/ No				WORK ORDER NON-C	COL	NFORM	MANCE / UP	DATE			6
											QA Closed:	Date	:
Vork Orde	r:					DISPOSITION				AGAINST D	EPARTMENT/	PROCESS	
Part N	o					Rework Scrap Use-as-is		Therm	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
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Root Cause		Date	Step	Qty	Desc	otion of work order update	ł	nitial ief Eng		tion ription	Sign & Date	Verification	QC Inspector
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-		Sending Centre No Cracks Crushed/C Cuffs Heat Treat Inspection Ripples in	Crimped. t n Strip in Bend aves in E	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset Out of O	on Incomplete ions Incomplete/ nance led I	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	et ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
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Outside Dimensions

Wave/Twist in Tube

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Quality Control

## Work Order ID 107654

\*107654\*

Page 3

September-27-13 1:05:27 PM Accept Item ID: D2204-9 \*N900040100\* Setup Start **Revision ID:** Rubber Latches Item Name: \*10\* **Start Oty: 10.00 Start Date:** 9/27/13 **Cust Item ID:** \*10\* Required Date: 9/27/13 Req'd Qty: 10.00 **Customer:** Reference: Start Run Process Plan: Tooling: Approvals: Date: Date: Stop **SPC (Y/N):** Date: QC: Date: Reject Reject Tool ID Tool # Plan Insp. Set Up/ Accept Sequence ID/ Operation Number Stamp Qty Qty Code Work Center ID Description **Run Hours** Identify as per dwg & Stock Location: 572,38 0.00 160 \*160\* 0.00 Packaging Memo Packaging QC21- Final Inspection - Work Order Release 0.00 170 \*170\* 0.00 QC Memo

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	COI	VFOR	MANCE / UPDATE				<u>-</u>
						-			<u></u>			QA Closed:	Date:	
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Cause		Date	Step	Qty		O	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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		Ripples in	Bend		ſ		Drill Holes		Offset		_	-		
		Torque W	aves in E	xtrusion	· [		Drawing		Out of (	Calibration				
		Turning Se	equence				Finish		Out of 9	Sequence				

Outside Dimensions

Wave/Twist in Tube

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**Picklist Print** 

September-27-13 1:05:26 PM

Work Order ID: Parent Item:

107654 D2204-9

Parent Item Name:

Rubber Latches

**Start Date: 9/27/13** 

Required Date: 9/27/13

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP E02.06.11Added finishRF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
286-750-017		Purchased	No			100	Each	0.0000	1	10	R	1/10	
Rubber Latch									<del></del>		179	1198	(1)

												DQA:	Date	። _	*
NCR:	Yes	/ No					WORK ORDER NON-C	100	VFOR	MANCE / UPI			_		•
							·					QA Closed:	Date	<u>::</u>	
Nork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Part							Rework Scrap Use-as-is		ı	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR	No.		. <u></u>				Work Order Update	]		Large Fab	Composite		Supplier		
Root					Des	cri	otion of work order update		nitial	Act	tion	Sign &		T	
Cause		Date	Step	Qty			or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification		QC Inspector
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		Centre No	ot Concer	ntric to	o/s		BOM/Route		Hardwa	re		Over/Under	tolerance	$\neg$	Temperature/Cure
		Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	٦,	Weld
		Crushed/0	Crimped.				Burrs	Г	1	ions Incomplete/I	Unclear	Part Lost/Mi	ssing	٦,	Wrong Stock Pulled
		Cuffs					Contamination		Mainte			Part Moved	~ <u>L</u>	_	
		Heat Trea	t				Countersink		Mislabe	led		Positioned V	Vrong		
		Inspection	n Strip in	Tube			Cut Too Short		Misread	l		Power Loss/		$\Box_{\epsilon}$	Other
		Ripples in					Drill Holes		Offset		<u> </u>	J,	Č		
		Torque W		xtrusio	n		Drawing		ł	Calibration					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

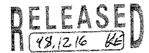
Finish

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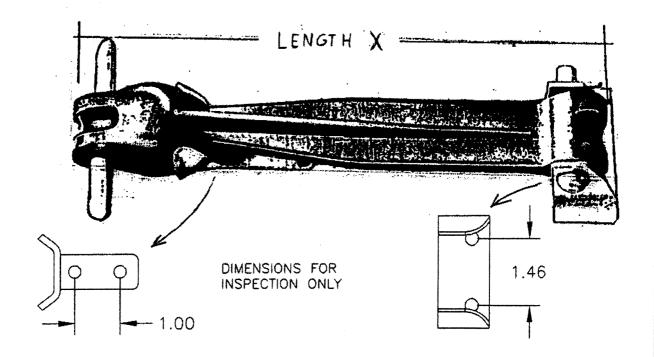


DESIGN	DRAWN BY	DART AEROSPACE LTD	
AE	"   XE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. REV	. в
-##-	1 X	D2204 SHEET 1 0	FI
DATE	<del></del>	TITLE SC	ALE
98.12.1	5	LATCH, RUBBER	NTS
Α	93.11.15	NEW ISSUE	
В	98.12.15	UPDATED PICTURE, ADD VENDOR P/N	*****





## SPECIFICATION CONTROL DRAWING



D2204-X RUBBER LATCH WITH BRACKETS

LENGTH

EG: 9" LONG: D2204-9

5" LONG: D2204-5

POSSIBLE SUPPLIERS: ACCURATE RUBBER.

P/N 286750017 FOR 9" LATCH ASSEMBLY P/N 286750010 FOR 9" RUBBER ONLY



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

## **PURCHASE ORDER**

Purchase Order ID PO21539

Purchase Order Date 10/1/2013 PO Print Date 10/1/2013

Page Number 1 of 1

Order From:

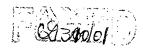
ACR GROUP INC. 12771 - NO. 5 ROAD RICHMOND, BC V7A 4E9 CA VC-ACR001

Ship To: DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

**CANADA** 



Contact Name

Vendor Phone

604 274 9955

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607 Net 30

Terms Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact Ship To Phone

Ship Via:

FedEx PI collect

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date		Req Qty/ Unit of Measure		PO Unit Price	Extended Price
1	286-750-017	Rubber Latch	10/7/2013 Yes		10.00 Each		\$17.00	\$1.70.00
	AS PER DWG D2204 REV. B B107654		10/7/2013	(		<b>.</b>		

Line Total:

\$170.00

PO Total:

\$170.00

h of

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required YES

PST# 6122-5207

1

Change Nbr:

Change Date:

10/1/2013



www.acrgroup.ca

0

12771 No. 5 Road Richmond, B.C. Canada V7A 4E9 PACKING SLIP CUSTOMER COPY

Tel: 604-274-9955 Fax: 604-274-1013

Toli Free: 1-888-478-2237

PACKING SLIP

ØØ148321

CUSTOMER NO.

10750

PST#

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

DART AEROSPACE LTD
1270 ABERDEEN STREET
1 HAWKESBURY ON K6A 1K7
P Canada

DATE	SHIP VI	A A	T	ERMS	
10/01/13 DAY &	ROSS	ACR GROUP LINC. NET 30 DA	VS	17.45.	
PURCHASE ORDER NUMBER P021539	10/01/13	ØØ148321		ROB	ERSON
QUANTITY ORDERED SHIPPED B.O.	ITEM NUMBER	DESCRIPTION	UNIT	UNIT PRICE	AMOUNT
10 10	- 28675ØØ17	9" HOOD HOOKS - COMPLETE SET	EA S		
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FREIGHT: Colle	ct	TOTAL AMOUNT			
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12771 No. 5 Road Richmond, B.C. V7A 4E9

Canada

Telephone: (604) 274-9955

Fax: (604) 274-1013

## **CERTIFICATE OF COMPLIANCE**

		Date :	10/08/2013
Customer:	Dart Aerospace LTD	<u> </u>	
Customer P.O. #	: PO21539		
			•
ACR W.O. #:	148321	Item#:	286750017
Item Description:	9" Hood Hooks - Complete		
ACR Compound	: <u>C - 3270</u>		
Date Shipped:	October 8, 2013		

This Certifies that to the best of our knowledge the material delivered under this contract is in accordance with the terms of the contract, and with ACR Group quality standards.

Mike Reilander

(ACR GROUP INC. REPRESENTATIVE)